



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3312-03-3-PO
Job Sheet 177388



Part No: RBE350A93-3312-03-3-PO

Job Qty: 50 ea

Part Name: Remover / Installer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/10/18

Job Tracking No:

Due Date: 6/8/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE350A93-3312-03 Rev. G IPP Rev. A 18.05.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	50 pcs	6/8/18	6/8/18	0.00	0.00	Purchasing		AT 18/06/28
110	Packaging	50 pcs	6/8/18	6/8/18	0.00	0.00	Packaging2		AT 18/06/28
120	QC	50 pcs	6/8/18	6/8/18	0.00	0.00	QC6		38
130	Packaging	50 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3		SD 18/06/28
140	QC21-FG	50 Ea	6/8/18	6/8/18	0.00	0.00	QC21		21 JUL 03 2018

Part Op 100 - Issue P/O: 039860 MANUFACTURE RBE350A93-3312-03-3 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

10 Mai 2018 x 50 R L

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A93-3312-03-3P	Remover / Installer	50 (1 ea)	100-Purchasing	5088383
				5088409

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE350A93-3312-03-3P	50	0	0

Part Specifications

Specifications could not be found.

Plex 5/10/18 9:16 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S088414



Part: RBE350A93-3312-03-3

Job No: 177388

Serial No/Batch: S088414

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 06/29/16

BAL
GC
2016

BAL
TS
2016



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3312-03-3

Job Sheet 173897



Part No: RBE350A93-3312-03-3

Job Qty: 8 ea

Part Name: Remover / Installer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3312-03 Rev F IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		3/31/18	0.00	0.00	Start Up Machining-3		
120	CNC Lathe	6 pcs		4/2/18	0.00	6.00	MORI SL-154		
130	QC	6 pcs		4/2/18	0.00	0.00	QC2 Machining-4		
140	QC	6 pcs		4/2/18	0.00	0.00	QC8 Machining-4		
170	Outsource	6 pcs		4/14/18			GRO002-VC	10	
180	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging2		
190	QC	6 pcs		4/14/18	0.00	0.00	QC6		
200	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging3-1		
210	QC21-SA	6 Ea		4/14/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per DWG. FB783 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Descriptions: 170 - -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.500	AlSi 4140 Quenched &Tempered Steel Round Bar 1.500" Dia.	.5400 ft (.09 ea)	90-Start up Operation	

Job Allocations

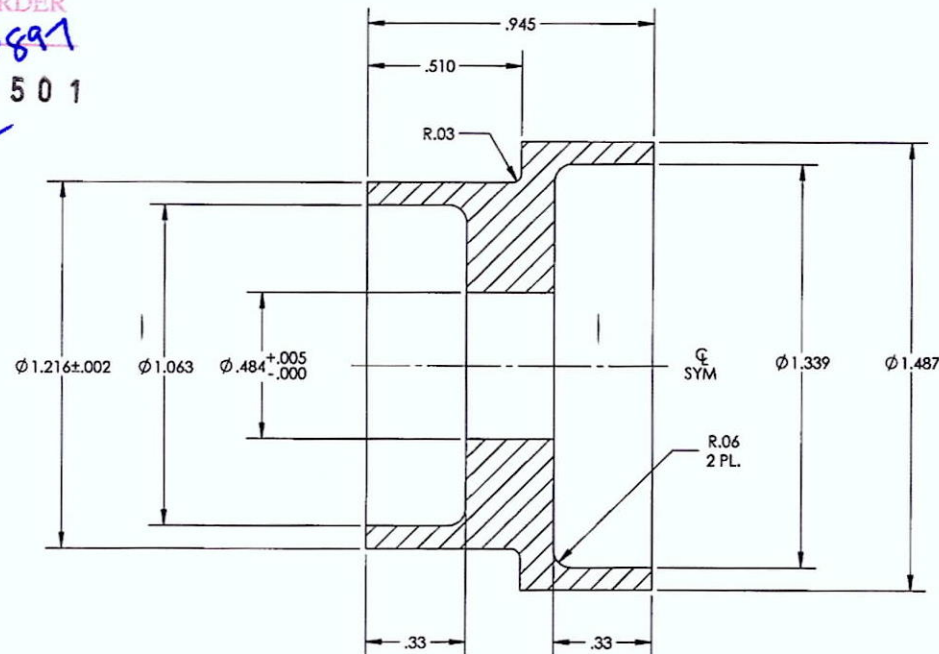
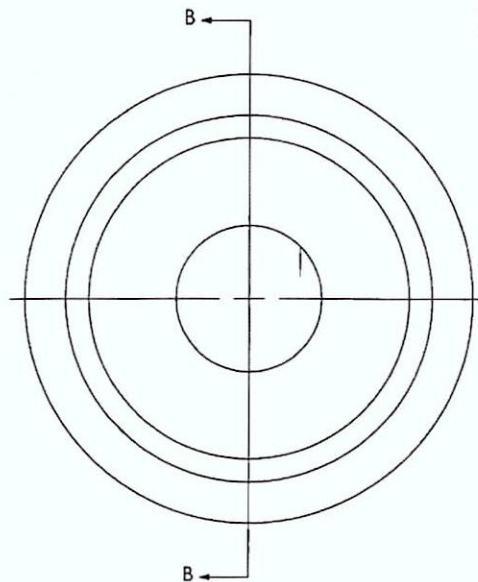
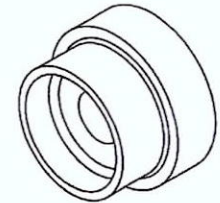
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.500	1	28	0

Part Specifications

Specifications could not be found.

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	DIMENSION .473 CHANGED TO .484, TEMPLATE UPDATED, SPEC FOR BLACK OXIDE CHANGED, 17-4PH SS MTL OPTION ADDED	17-803	17.12.27	VM	ML
G	28-32 Rc REMOVED	18-582	18.3.1	VM	ML

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WORK ORDER
NO. 173891
20180501



RBE350A93-3312-03-3 REMOVER / INSTALLER

SECTION B-B

NOTES:

- 1) MATERIAL: 4140/4142 OR 17-4PH-H900 SS
- 2) HEAT TREAT: N/A
- 3) FINISH: 4140/4142 = BLACK OXIDE / 17-4PH = NONE
- 4) SPEC: 4140/4142 = MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4 / 17-4PH = N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkebury, Ontario, Canada	
REMOVER / INSTALLER	
PART NO.	REV
RBE350A93-3312-03-3	G
TOOL NO. RBE350A93-3312-03	
INITIALS AND DATE	
DESIGNED BY: VM 12/27/2017	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING
DRAWN BY: VM 03/01/2018	TOLERANCES: X .005 X .01 X .1
CHECKED BY: VM 03/01/2018	FRACTIONS: $\frac{1}{8}$ ANGLES: $\frac{1}{2}^\circ$ SURFACE: ROUGHNESS
MFG REVIEW BY: JFC 03/01/2018	SCALE: NTS
APPROVED BY: ML 03/01/2018	SHEET 3 OF 5
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039860**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039860
PO Date: 5/10/18
Due Date: 6/25/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick Phone:

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9		RBW6305G00232-3G-1P			Base	Firmed	6/25/18	25 Ea	0 Ea	25 Ea	\$0.01/Ea	\$0.25
Line Item Note W/O 177409 , please advise Pat Lussier once received												
11		RBW109-3101-58-1-7P			Handle	Firmed	6/25/18	50 Ea	0 Ea	50 Ea	\$9.45/Ea	\$472.50
Line Item Note W/O 177380												
12		RBW109-3101-58-2-7P			Handle	Firmed	6/25/18	50 Ea	0 Ea	50 Ea	\$9.45/Ea	\$472.50
Line Item Note W/O 177383												
13		RBE350A94-2708-01-01P			Slide	Firmed	6/25/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177384												
14		RBE350A93-3312-03-7P			Washer	Firmed	6/25/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177385												
15		RBE350A93-3312-03-5P			Seat	Firmed	6/25/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177387												
16		RBE350A93-3312-03-3P			Remover / Installer	Firmed	6/25/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177388												
18		RBE350A93-3400-00-1P			Guide	Firmed	6/25/18	50 Ea	0 Ea	50 Ea	\$0.01/Ea	\$0.50
Line Item Note W/O 177390												
19		C2-22P			SWA3 Lifting Bushing	Firmed	6/25/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
Line Item Note W/O 177393												

Plex 6/15/18 3:36 PM dart.Lussier.Patrick

6/15/2018

PURCHASE ORDER

Items												
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
21		RBW6305G01232-3G-1P			Receiver	Firmed	6/25/18	27 Ea	0 Ea 27x	27 Ea	\$72.35/Ea	\$1,953.45 27x 72.35 = 1953.45
Line Item Note		W/O 179292										
											Grand Total:	\$2,901.50

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
 A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
 A012 CHEMICAL AND PHYSICAL TEST REPORTS
 A016 PERSONNEL QUALIFICATION
 A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
 A026 CERTIFICATION OF MATERIAL CONFORMANCE
 A041 QUALITY MANAGEMENT SYSTEM
 A042 DART NOTIFICATION BY SUPPLIER
 A043 RETENTION OF QUALITY DOCUMENT

 A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

 A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/15/18 3:36 PM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.**

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22804

Date:

Jun 28, 2018

Page:

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Sold to:	Ship to:
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO039860	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Jun 28, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
RBE350A93-3312-03-3P Remover / Installer		Each	50	50	
RBE350A93-3303-02-5P Extractor Pin		Each	50		
RBE350A93-3400-00-1P Guide		Each	50		50
C2-22P SWA3 Lifting Bushing		Each	30		
RBW1205G00231-3G-7P Washer		Each	30		
added June 15, 2018: Base, dwg # RBW6305G00232-3G-1 Rev.2		Each	25	25	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					

DAS
38
9-89

Received by _____

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	P.O. Number
50	RBE350A93-3312-03-3P	Remover / Installer	39860
25	RBW6305G00232-3G-1P REV. 2	Base	39860

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

DAS
38
9-89

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, June 28, 2018